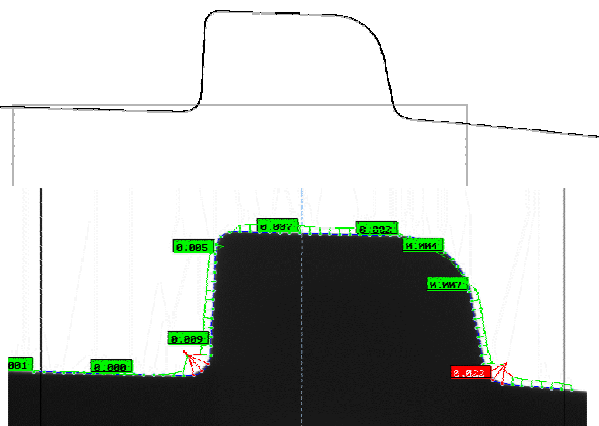
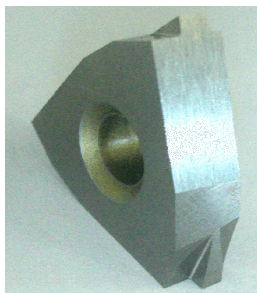
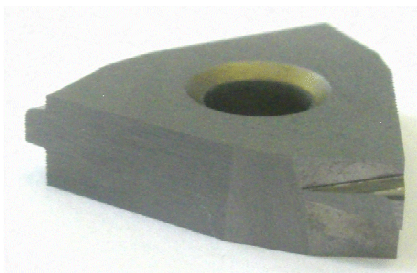


Single-Threadinsert on edge Z3

A08-250

The triangular Threadinsert with single-threadform with profileorientation on edge can be ground in one setup using standard TTC clamping. The pregrinding and finishing operations are using 20 degree V-shaped wheels of diameter 250 and 200 mm. If the OD has be ground, the front of a cup wheel or the periphery of an 1A1 wheel can be used.



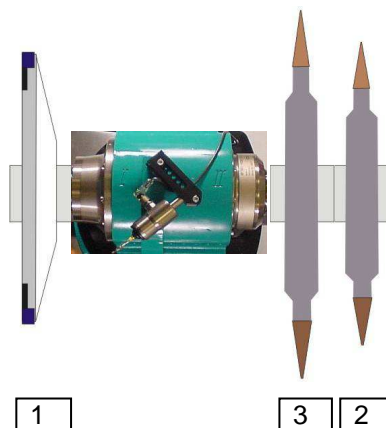
1. Cycletime for Production

Workpiece:	Triang. Di 16 mm, B 6.45 mm Material CARBIDE					
Operations						
Feed [mm/Min]	2000	100	20	25	20	9000
Power [kW]		1	2	1	2	1
Cutting feed [m/s]		24	24	24	24	
Used wheels						
Grinding time [s]	6	34	100	135	165	45
Total cycle time	8 Min 5					

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

2. Used Grinding Wheels

1	12C9 Ø200 D64
2	14EE1 Ø200 D76V20°
3	14EE1 Ø250 D46V20°



3. Machine and Software Requirements

Machines: 5 axes CNC grinders : SIRIUS HPM
Control: Fanuc 160i/310i
Accessories: STL6051, TTC Clamping

Coolant: Synthetic Oil, pressure 6 bar
Software: Quinto 5

Responsible engineer: OP, 4.6.10

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